

Work Order ID 71826

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Tuesday, July 12, 2011 2:47:30 PM

Item ID: D2596

Accept



Setup Start



Revision ID:

Stop



Item Name: Web, 205 Skidtube

Start Date: 7/12/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: 

Date: 11-07-13

Tooling:

Date:

Run Start



QC:




Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2596	Rev D								
100		0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.630" diameter as per Dwg D2596 4- Deburr								
110	Chemical Conversion Coat per QSI005 4.1	0.00							
	HandFinish								
Hand Finishing	Memo	0.00							
120	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
Quality Control	Memo	0.00							

(4)

11/07/13

(4)

11/07/13

11-7-13

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			






NOTE: Date & initial all entries



Work Order ID 71826



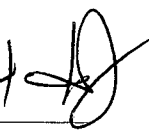
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Item ID: D2596 Accept  Setup Start 
Revision ID:
Item Name: Web, 205 Skidtube Stop 
Start Date: 7/12/2011 Start Qty: 4.00  Cust Item ID:
Required Date: 7/15/2011 Req'd Qty: 4.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging	Identify as per dwg & Stock Location: <u>LC</u>	0.00				<u>4</u>		<u>3B</u>	<u>11/07/13</u>
Packaging	Memo	0.00							
140  QC	QC21- Final Inspection - Work Order Release	0.00							<u>11/7/14</u> 
Quality Control	Memo	0.00							<u>MF</u> <u>11-07-14</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 71826

Parent Item: D2596

Parent Item Name: Web, 205 Skidtube



Start Date: 7/12/2011

Required Date: 7/15/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: D□99.02.02□Changed QA to QC, Added Step 6 and Cost□DM
IPP Rev:E 07-07-09 Incorporated DEO 9183 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2500-3-100

Manufactured

No

100

Each

135.0000

1



Ext'n -I' Beam Web 4"



4

B 11/07/13

Location

Loc Qty

Loc Code

LG

135

51957

4

66298

131

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



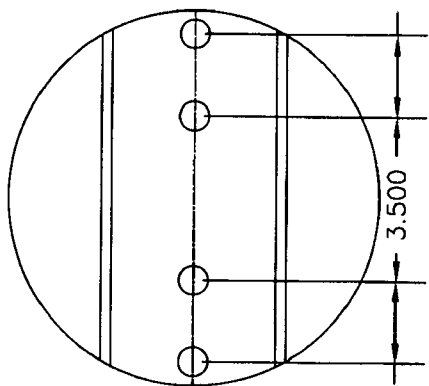
DESIGN PH		DRAWN BY PH		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED HH		APPROVED HH		DRAWING NO. REV. D D2596 SHEET 1 OF 1	
DATE 07.04.17		TITLE 205 WEB		SCALE 1:20	
A	96.09.16	NEW ISSUE			
B	97.07.23	ø0.63 HOLE WAS ø0.56			
C	98.09.14	INCORPORATED DEO 9097			
D	07.04.17	INCORPORATED DEO 9183			

RELEASED
07-06-68

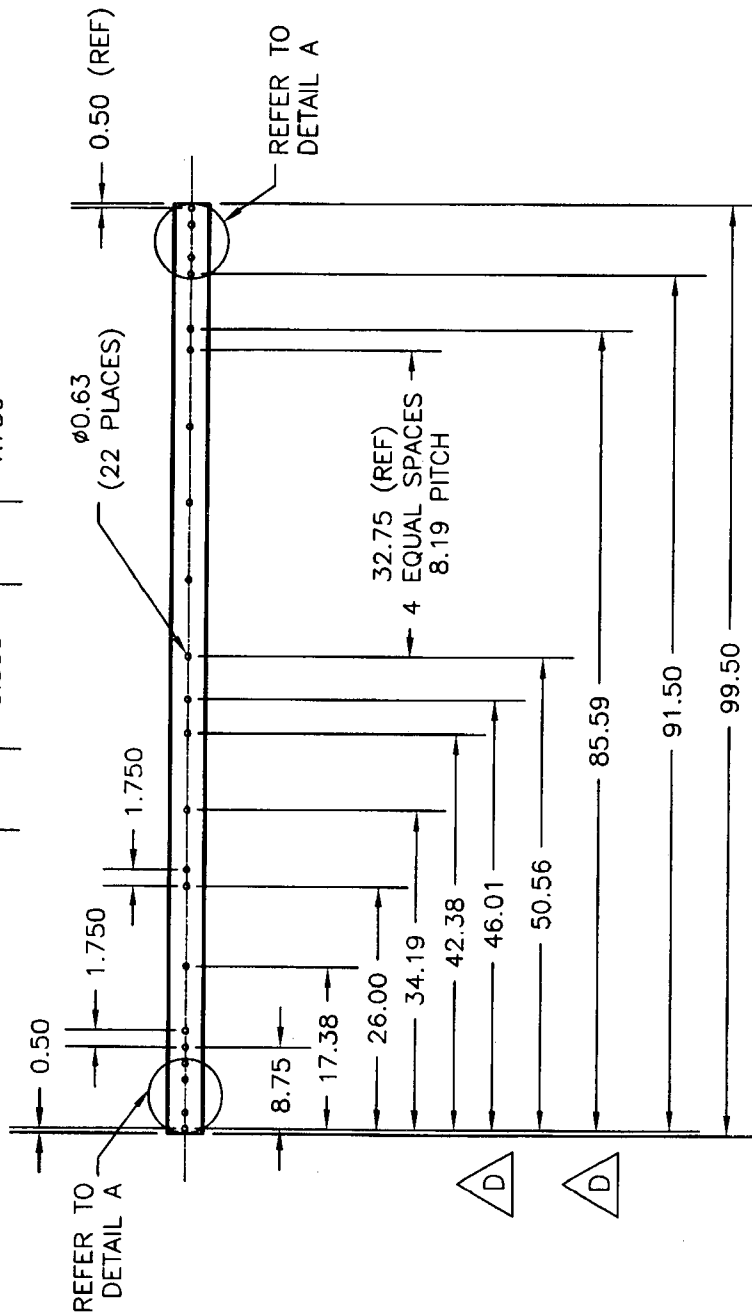
SHC
REF

UNCONFIDENTIAL
SUBJECT: [REDACTED]
WITHOUT
WORK
NO. 718

1825
11-07-13



DETAIL A
SCALE 1:4



D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) DEBURR SHARP EDGES 0.010 TO 0.020

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